

Date: Tuesday, 16/01/2007 9:56:59 AM
User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : STIFFNER
Job Number : 30287	
Estimate Number : 12641	
P.O. Number : N/A	Part Number : G106043
This Issue : 16/01/2007 S.O. No. : N/A	Drawing Number : G10604 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : SMALL /MED FAB	Drawing Revision : A
Previous Run : N/A	Material : N/A
Written By : <u>[Signature]</u>	Due Date : 26/01/2007 Qty: 10 Um: Each
Checked & Approved By : <u>[Signature]</u>	
Comment : Est Rev:A New Issue 07-01-16 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0	M2024T3S050	2024-T3 .050 sheet
-----	-------------	--------------------



Comment: Qty.: 0.2615 sf(s)/Unit Total: 2.6145 sf(s)

2024-T3 .050 sheet

*****Grain must Run Along 8.59" Dim *****

Batch: M103210

ml 07 01 16

(10)

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET

1-Cut as per Dwg G10604

Dwg Rev: A

Prog Rev: A

ml 07 01 16

(10)

2-Deburr if necessary

SB

07/01-18

(10)

*****Use same cutting file for -3 & -6 *****

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

ml 07 01 16

(10)

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

07/01/16

(10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 07/01/22

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 16/01/2007 9:56:59 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STIFFNER

Job Number: 30287

Part Number: G106043

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-C'SINK AS PER DWG G10604,

****NOTE:-3 & -6 ARE C'SINKED ON OPPOSITE SIDES****

2-FORM AS PER DWG G10604

FF 07-01-19

83 07/01/19

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/01/19 (10)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

HSI

07-01-22 (10)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

07/01/22

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

07/01/22 (10)

07/01/22

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/01/22

Job Completion



07/01/22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

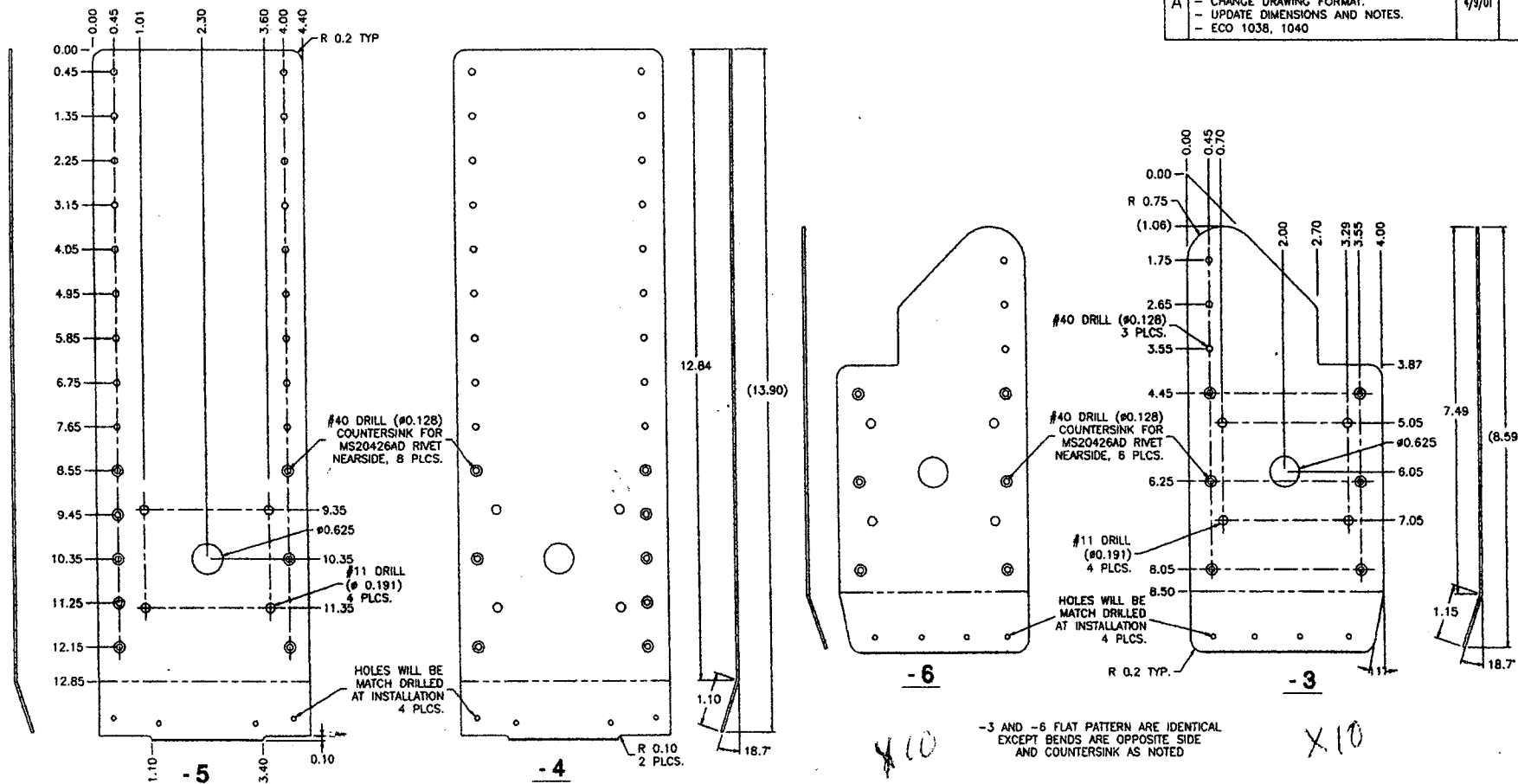
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

REVISION		DATE	APPROV.
REV	DESCRIPTION		
A	- COMBINE SHEET 1 AND 2. - CHANGE DRAWING FORMAT. - UPDATE DIMENSIONS AND NOTES. - ECO 1038, 1040	4/9/01	



-4 AND -5 FLAT PATTERN ARE IDENTICAL
EXCEPT BENDS ARE OPPOSITE SIDE
AND COUNTERSINK AS NOTED

NOTES:

UNLESS OTHERWISE NOTED.

- MAT'L: ALUM 0.050 THICK, 2024-T3
QQA-250/4
- ALL PILOT HOLES ARE #40 DRILL (#0.098).
TO BE DRILLED TO SIZE AT ASSEMBLY.
- FINISH: ETCH, ALODINE PER MIL C5541-1A,

BROWN ALL EDGES		✓	DATE	3/20/95
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		CHECK	T. S.	
DIMENSIONAL TOLERANCES		DESIGN	DATE	
3 DECIMALS ± 0.010		APPROVAL	DATE	4/3/95
2 DECIMALS ± 0.020		RCC		
1 DECIMAL ± 0.050				
ANGULAR ± 1°				
THIS DRAWING INCLUDES INFORMATION PROPRIETARY TO GENEVA AVIATION AND SHALL NOT BE USED OR REPRODUCED BY ANYONE WITHOUT THE WRITTEN PERMISSION OF GENEVA AVIATION INC.				
DRAWN BY: G10604			REV: A	
PROJ NO: GA159			SIZE: D 1/1	

GENEVA AVIATION
10108 - 32nd Ave W
Everett, WA 98204
(425)353-7400 FAX(425)347-7100

REAR SHOULDER HARNESS
STIFFENER

SHIP TO: DATE: 12/01/07 BY: [Signature]					
SOLD TO: [Signature] [Signature]					
CUSTOMER PO NUMBER: N18187		WORK PACKAGE:		CUSTOMER PART NUMBER:	
KAISER ORDER NO: 1033832		LINE ITEM: 1		SHIP UNLOAD ID: 100880/10	
WEIGHT SHIPPED: 7885 LB		SHIP DATE: 24-MAR-2008		GOVT CONTRACT NUMBER:	
QUANTITY: 223 PCS EST.		ALLOY: 2024		CLAS: CLAD	
M/L NUMBER: 207855		GAUGE: 0.0800 IN		TEMPER: T3	
		WIDTH: 48.000 IN		LENGTH: 144.000 IN	

KAISER ALUMINUM

Trentwood Works - Spokane, WA 99215
Phone: (800) 367-2586

CERTIFIED TEST REPORT

Serial Number
4062914

Certified Specifications

AMS 4041/RevP
BATS 2505/RevNC

AMS QQ-A-280/5/RevA
DMS 2174/RevB

ASTM B 209/Rev04

Test Code: 4013

Lot: 350042A8 Cast 318

Drop 16

Ingot 2

Test Results

Tensile:	Temper	Dr / # Tests	Ultimate KSI (MPA)	Yield KSI (MPA)	Elongation %
	T3	LT / 2 (Min:Max)	63.8 : 64.7 ✓ (441 : 445)	44.8 : 45.8 ✓ (309 : 318)	15.8 : 17.0 ✓

MPS Deflection: 0.017 IN

Chemistry:	SI	FE	CU	MN	MG	CR	ZN	TI	V	ZR	OTHER
Actual	0.09	0.24	4.57	0.58	1.40	0.01	0.13	0.02	0.01	0.01	TOT 0.04

ALLOY LIMITS

Chemistry:	SI	FE	CU	MN	MG	CR	ZN	TI	V	ZR	OTHER	MAX
2024 MIN	0.00	0.00	3.80	0.30	1.20	0.00	0.00	0.00	0.00	0.00	EACH	0.06
MAX	0.50	0.50	4.90	0.90	1.80	0.10	0.25	0.15	0.05	0.05	TOT	0.15
LINER MIN	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	EACH	0.03
MAX	0.25	0.40	0.05	0.05	0.05	0.00	0.05	0.03	0.05	0.00	TOT	0.00

Aluminum Remainder

TEST NOTES

MATERIAL MEETS MINIMUM RESIDUAL STRESS (MRS) CHEMICAL
MILLING QUALITY (CMQ) REQUIREMENTS.

